

Date: Monday, 4/23/2007 3:41:38 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	LUG ASSEMBLY 206L/407 GHW LUG	
Job Number	32018	Part Number	D2659	
Estimate Number	10318	Drawing Number	D2659 REV A	
P.O. Number	N/A	Project Number	N/A	
This Issue	4/23/2007	S.O. No.	N/A	
Prsht Rev.	NC	Type	PURCHASED PARTS	
First Issue	N/A	Material	N/A	
Previous Run	29780	Due Date	5/18/2007	
Written By	Qty: 33 Um: Each			
Checked & Approved By	07/04/23			
Comment	Est: D 02.09.20 Re-format; Incorporated D2657; D2658 KJ/RF			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	32018A	LUG	
	Comment: Sub-Component LUG D2657 B 32376, 32 3292289 x1	FC 07/07/04 (33)	
2.0	32018B	LUG BRACKET	
	Comment: Sub-Component LUG BRACKET D2658 B 32018 b	FC 07/07/04 (33)	
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
	Comment: LARGE FABRICATION RESOURCE 1 1-Weld as per Dwg D2659 using location Jig DT8484 A/Steel Rod m103794	FC 07/07/04 (33)	
4.0	QC9	VISUAL WELDING INSPECTION	
	Comment: VISUAL WELDING INSPECTION	11/07/07/05 (33)	
5.0	QC5	INSPECT WORK TO CURRENT STEP	
	Comment: INSPECT WORK TO CURRENT STEP	11/08/07/05 (33)	
6.0	POWDER COATING	POWDER COATING	
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	BR/Fd. 07-07-09 (33)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/07/10
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 3:41:38 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY 206L/407 GHW LUG

Job Number: 32018

Part Number: D2659

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

4/207/07/10 (33)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

4/207/07/10 (33)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

4/207/07/10

Job Completion



C 4/207/07/10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

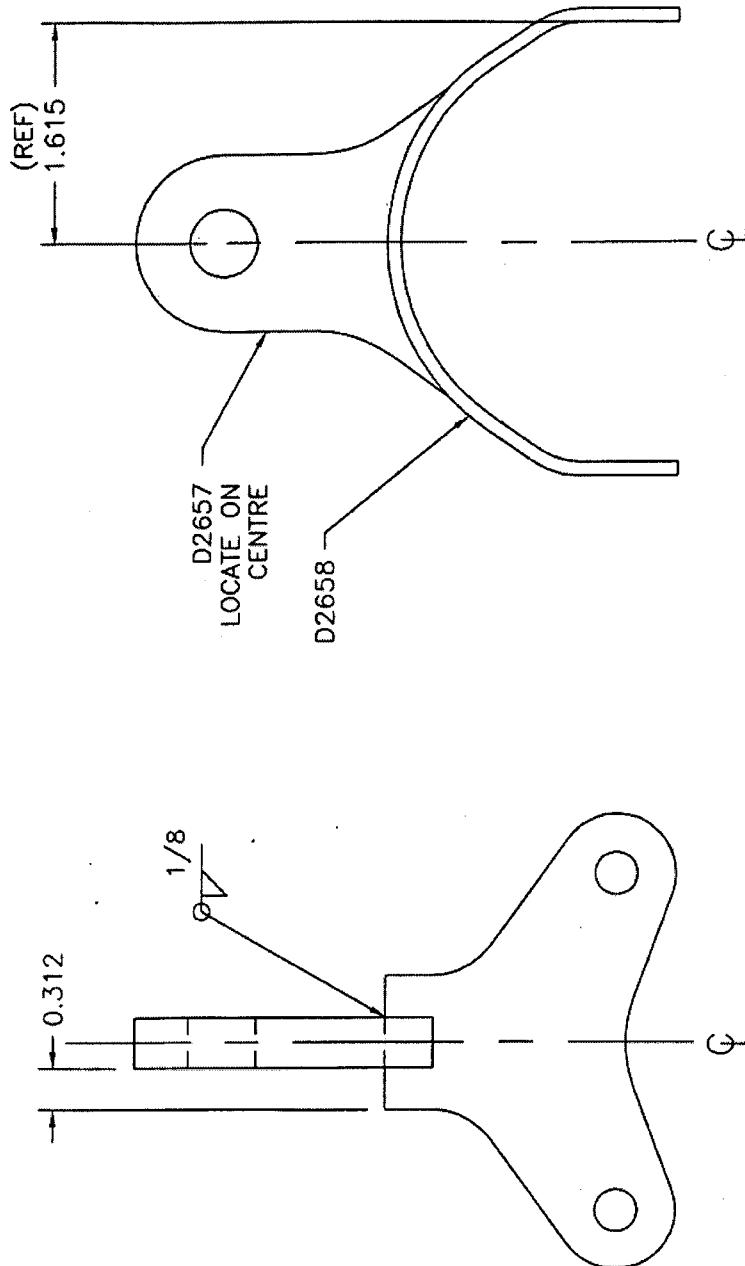
NOTE: Date & initial all entries

DART

04 COPY
DRAFT

DESIGN <i>D108</i>	DRAWN BY <i>D108</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>S</i>	APPROVED <i>U</i>	DRAWING NO. D2659
DATE 97.11.03		TITLE LUG ASSEMBLY
A	97.11.03	SCALE NTS
		NEW ISSUE

RELEASED
97/11/06 DS



D2659 LUG ASSEMBLY

WELD PER DART QSI 004
FINISH: POWDER COAT PER DART QSI 005 4.4
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTRE-LINES (Q)

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
32018